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(54) Title: PROCESS FOR THE PREPARATION OF DONEPEZIL AND DERIVATIVES THEREOF

(57) Abstract: The invention relates to processes for the preparation of piperidylmethyl-indanones, and to the use of these compounds as intermediates for the preparation of benzyl-piperidylmethyl-indanones which are active compounds for the treatment of CNS disorders. The invention also relates to a process for the preparation of donepezil or a pharmaceutically acceptable salt thereof, and pharmaceutical compositions that include the donepezil or a pharmaceutically acceptable salt thereof.

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PROCESS FOR THE PREPARATION OF DONEPEZIL AND DERIVATIVES THEREOF

Field of the Invention

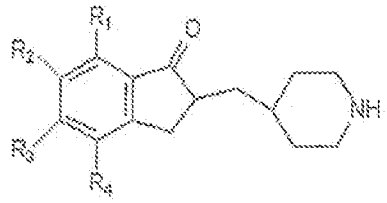
The field of the invention relates to processes for the preparation of piperidylmethyl-indanones, and to the use of these compounds as intermediates for the preparation of benzyl-piperidylmethyl-indanones which are active compounds for the treatment of CNS disorders. The invention also relates to a process for the preparation of donepezil or a pharmaceutically acceptable salt thereof, and pharmaceutical compositions that include the donepezil or a pharmaceutically acceptable salt thereof.

Background of the Invention

Benzyl-piperidylmethyl-indanones such as donepezil have an excellent pharmacological action as prophylactic or medicament for senile dementia, especially for Alzheimer disease. Several processes have been reported for the preparation of benzyl-piperidylmethyl-indanones for example, in U.S. Patent Nos. 4,895,841; 5,606,064; 6,252,081; 6,413,986; WO 97/22584 and J. Med. Chem. 1995, 38 (24), 4821-4829. These processes require multiple steps or complicated purification processes such as chromatography and therefore inevitably lead to poorer yields or purity.

Summary of the Invention

In one general aspect there is provided a process for preparing 2-(4-piperidinyl) methyl-1-indanone of formula II, or a salt thereof,



Formula II

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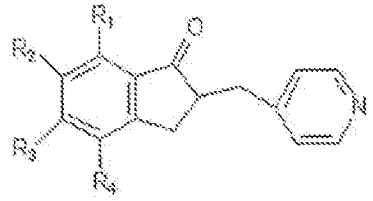
wherein R^1, R^2, R^3, and R^4 are identical or different, and represent hydrogen or straight or branched -chain alkyl, alkoxy, alkoxycarbonyl, alkyl- or dialkyl-aminocarbonyloxy, trifluoromethyl, or halogen. The process includes reducing 2-(4-pyridyl) methyl-1-indanone of the formula III, or a salt thereof,



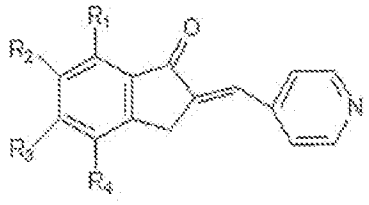
Formula III

wherein R^1, R^2, R^3, and R^4 are as defined above; and recovering the 2-(4-piperidinyl)methyl-1-indanone of formula II, or a salt thereof.

Recovering the 2-(4-piperidinyl) methyl-1-indanone may include one or more of distillation, distillation under vacuum, filtration, filtration under vacuum, decantation and centrifugation.

The process may include further drying of the product obtained.

In another general aspect there is provided a process for preparing the 2-(4-pyridyl) methyl-1-indanone of formula III, or a salt thereof, wherein R^1, R^2, R^3, and R^4 are as defined above. The process includes selectively reducing 2-(4-pyridyl) methylene-1-indanone of formula IV, or a salt thereof,



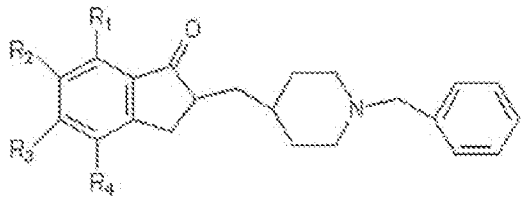
Formula IV

wherein R^1, R^2, R^3, and R^4 are as defined above; and recovering the 2-(4-pyridyl) methyl-1-indanone of formula III, or a salt thereof.

Recovering the 2-(4-pyridyl) methyl-1-indanone may include one or more of distillation, distillation under vacuum, filtration, filtration under vacuum, decantation and centrifugation.

The process may include further drying of the product obtained.

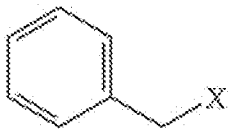
In another general aspect there is provided a process for preparing benzyl-piperidylmethyl-indanones of formula I, or a salt thereof,



Formula I

wherein R^1, R^2, R^3, and R^4 are as defined above.

The process includes reacting the 2-(4-piperidinyl) methyl-1-indanone of formula II, or a salt thereof, with a benzyl derivative of formula V,



Formula V

wherein X is a leaving group, in the presence of a base; and recovering the benzyl-piperidylmethyl-indanones , or a salt thereof.

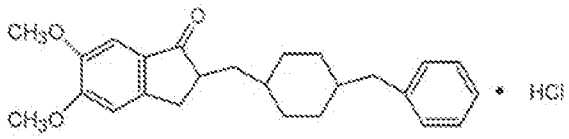
Recovering the benzyl-piperidylmethyl-indanones may include one or more of distillation, distillation under vacuum, filtration, filtration under vacuum, decantation and

centrifugation.

The process may include further drying of the product obtained.

The Compounds of formula I may thus be obtained in good yield and purity without resorting to chromatographic purification.

In another general aspect there is provided an improved process for preparing donepezil of formula VI, or a pharmaceutically acceptable salt thereof.



Formula VI

The process includes reacting 2-(4-piperidinyl) methyl-1-indanone of formula II, or a salt thereof, wherein R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy, with a benzyl derivative of formula V, wherein X is a leaving group, in the presence of an inorganic base and a phase transfer catalyst.

In another general aspect there is provided a pharmaceutical composition that includes a therapeutically effective amount of donepezil or a pharmaceutically acceptable salt thereof; and one or more pharmaceutically acceptable carriers, excipients or diluents.

The details of one or more embodiments of the inventions are set forth in the description below. Other features, objects and advantages of the inventions will be apparent from the description and claims.

Detailed Description of the Invention

The inventors have developed an efficient process for the preparation of 2-(4-piperidinyl) methyl-1-indanone of formula II, or a salt thereof, wherein R^1, R^2, R^3, and R^4 are identical or different, and represent hydrogen, or straight or branched -chain alkyl, alkoxy,

alkoxycarbonyl, alkyl- or dialkyl-aminocarbonyloxy, trifluoromethyl, or halogen.. The process involves reducing 2-(4-pyridyl) methyl-1-indanone of formula III, or a salt thereof.

Examples of alkyl groups include methyl, ethyl, n-propyl, isopropyl, and tert-butyl. Examples of alkoxy groups include methoxy, ethoxy, isopropoxy, and tert-butoxy. The term "halogen" includes fluorine, chlorine, bromine, and iodine. Examples of alkoxylcarbonyl include methoxycarbonyl, ethoxycarbonyl, isopropoxycarbonyl, and tert-butoxycarbonyl. Examples of alkyl- or dialkyl-aminocarbonyloxy include methylaminocarbonyloxy, and dimethylaminocarbonyloxy. In a particular example, R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy in the compounds of formula II and III.

In general, the reduction may be achieved by hydrogenation in the presence of a catalyst. The hydrogenation catalysts used for the reduction are the customary hydrogenation catalysts known in organic chemistry, for example transistion metal compounds. Examples of transistion metal compounds include platinum compounds such as platinum oxide, ruthenium compounds such as ruthenium oxide and rhodium compounds such as rhodium/carbon.

The hydrogenation may be carried out at normal pressure, or at elevated pressure depending on the choice of catalyst. In general, it may be carried out at a hydrogen pressure in the range from 1 to 10 atmospheres, or at a hydrogen pressure in the range from 1 to 2 atmospheres.

The hydrogenation may be carried out at a temperature from about -20°C to about 120°C, for example from about 0°C to about 80°C. In particular, it may be carried out at a temperature from about 10°C to about 35°C.

The compounds of formula II can be produced by methods known in the art such as the procedures disclosed in U.S. Patent No. 6,413,986; WO 97/22584, J. Med.Chem. 1995, 38 (24), 4821-4829, or obtained by the reduction of compounds of formula III.

The inventors have also developed a process for the preparation of 2-(4-pyridyl) methyl-1-indanone of formula III, or a salt thereof, wherein R^1, R^2, R^3, and R^4 are identical or different, and represent hydrogen, or straight or branched -chain alkyl, alkoxy, alkoxycarbonyl, alkyl- or dialkyl-aminocarbonyloxy, trifluoromethyl, or halogen.. The

process involves selectively reducing 2-(4-pyridyl) methylene-1-indanone of formula IV, or a salt thereof.

Examples of alkyl groups include methyl, ethyl, n-propyl, isopropyl, and tert-butyl. Examples of alkoxy groups include methoxy, ethoxy, isopropoxy, and tert-butoxy. The term "halogen" includes fluorine, chlorine, bromine, and iodine. Examples of alkoxylcarbonyl include methoxycarbonyl, ethoxycarbonyl, isopropoxycarbonyl, and tert-butoxycarbonyl. Examples of alkyl- or dialkyl-aminocarbonyloxy include methylaminocarbonyloxy, and dimethylaminocarbonyloxy. In a particular example, R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy in the compounds of formula III and IV.

The compounds of formula III can be produced by methods known in the art such as the procedures disclosed in U.S. Patent No. 6,252,081 or may be obtained by the selective reduction of compounds of formula IV.

In general, the reduction of the compound of formula IV to compound of formula III may be achieved by selective hydrogenation in the presence of a catalyst or by other conventional procedures for carbon- carbon double bond reduction, which do not reduce the pyridine ring of the compound of formula IV.

The inventors have observed that the formation of a complex mixture of impurities is minimized or eliminated altogether by avoiding direct reduction of the compound of formula IV to the compound of formula II.

In general, the reduction may be achieved by hydrogenation in the presence of a catalyst. The catalysts used for the selective hydrogenation are the customary hydrogenation catalysts known in organic chemistry, for example transistion metal compounds, used under milder conditions. Examples of suitable transistion metal compounds include platinum compounds such as platinum/carbon, palladium compounds such as palladium/carbon, palladium hydroxide, and nickel compounds such as Raney nickel.

The selective hydrogenation may be carried out at normal pressure, or at somewhat elevated pressure depending on the choice of catalyst. In general, it may be carried out at a

hydrogen pressure in the range from 1 to 5 atmospheres, or at a hydrogen pressure in the range from 1 to 2 atmospheres.

The hydrogenation temperature may be varied depending on the choice of catalyst and/or pressure employed. For example, the hydrogenation may be carried out at a temperature from about -20°C to about 60°C, or at a temperature from about 0°C to about 40°C. In particular, it may be carried out at a temperature from about 10°C to about 35°C.

The conventional procedures for selective carbon- carbon double bond reduction, which may be employed, include using hydrazine hydrate or ammonium formate /formic acid.

The compounds of formula IV are known compounds, and can be produced by methods known in the art such as the procedure disclosed in U.S. Patent No. 5,606,064, example 1.

Suitable solvents for hydrogenation of the compounds of formula II or IV are the customary inert solvents that do not change under the reaction conditions. Examples of such solvents include ethers, such as dibutyl ether, methyl tert-butyl ether, dioxane and tetrahydrofuran; alcohols such as methanol, ethanol, propanol, isopropanol and butanol; chlorinated hydrocarbons such as dichloromethane, tetrachloromethane and dichloroethylene; esters such as ethyl acetate and isopropyl acetate; ketones such as acetone and MIBK (methylisobutylketone); hydrocarbons such as hexane, toluene, and xylene; water; polar aprotic solvents such as dimethylformamide; dimethyl sulphoxide; N-methylpyrrolidone; and mixtures thereof.

The 2-(4-piperidinyl) methyl-1-indanone of formula II, or a salt thereof so obtained may be benzylated with a benzyl derivative of formula V, in the presence of an inorganic base and a phase transfer catalyst to give benzyl-piperidylmethyl-indanones of formula I, or a salt thereof.

The inventors have observed that the benzylation rection is faster in the presence of a phase transfer catalyst and side products are minimized. The compound of formula I may thus be obtained in good yield and purity without resorting to chromatographic purification.

The phase transfer catalysts used for preparing benzyl-piperidylmethyl-indanones of formula I, are not limited, including, for example, quaternary ammonium salts, and quaternary phosphonium salts. Examples of quaternary ammonium salts include tetramethylammonium iodide, tetrabutylammonium iodide, benzyltributylammonium bromide, 1-methylpiridinium iodide, teramethyl-2-butylammonium chloride, trimethylcyclopropylammonium chloride, tetrabutylammonium bromide, and t-butylethyldimethylammonium bromide. Examples of quaternary phosphonium salts include tributylmethylphosphonium iodide, triethylmethylphosphonium iodide, methyltriphenoxyphosphonium iodide, tetrabutylphosphonium bromide, benzyltriphenylphosphonium bromide, and tetraphenylphosphonium chloride.

The benzylation reaction may be carried out in a suitable solvent.

The term "suitable solvent" includes any solvent or solvent mixture which are inert and do not change the reaction. Examples of such solvents include water; ethers such as diethyl ether, dibutyl ether, methyl tert-butyl ether, dioxane and tetrahydrofuran; chlorinated hydrocarbons such as dichloromethane, and dichloroethylene; esters such as ethyl acetate and isopropyl acetate; ketones such as acetone and MIBK (methylisobutylketone); alcohols such as methanol, ethanol, propanol and isopropanol; acetonitrile; dimethylformamide; dimethyl sulphoxide; 1,2-dimethoxyethane; N-methylpyrrolidone; sulpholane; and mixtures thereof.

The temperature at which the benzylation reaction may be carried out may range from about -20°C to about 120°C, for example from about 0°C to about 40°C. In particular, it may be carried out at a temperature from about 10°C to about 35°C.

The base used for preparing a benzyl-piperidylmethyl-indanones of formula I, includes, for example an amine, an inorganic base or ammonia. Examples of amines include triethylamine, N-methyl morpholine, N,N-dimethyl benzyl amine, pyridine, picoline, and lutidine.

The inorganic base may be an alkali metal carbonate, bicarbonate or hydroxide. Examples of alkali metal carbonates include lithium carbonate, potassium carbonate and sodium carbonate. Examples of alkali metal bicarbonates include potassium bicarbonate and

sodium bicarbonate. Examples of alkali metal hydroxides include potassium hydroxide and sodium hydroxide.

The product obtained may be further or additionally dried to achieve the desired moisture values. For example, the product may be further or additionally dried in a tray drier, dried under vacuum and/or in a Fluid Bed Drier.

The present invention is further illustrated by the following examples which are provided merely to be exemplary of the invention and are not intended to limit the scope of the invention.

Preparation 1

Preparation of 5,6-dimethoxy-2-(pyridine-4-yl) methylene-indan-1-one

A mixture of 5,6-dimethoxy-indan-1-one (100g), pyridine-4-carboxaldehyde (67g), p-toluene sulfonic acid (118g) in toluene (1200ml) was refluxed azeotropically for 6 hours. The reaction mixture was cooled to room temperature and filtered. The wet solid so obtained was stirred with 10% aqueous sodium carbonate solution. The solid was filtered, washed with acetone and then dried to get the title compound (130g).

HPLC Purity: 99.5%

Example 1

Preparation of 5,6-dimethoxy-2-(4-pyridyl)methyl-indan-1-one.

5,6-dimethoxy-2-(pyridine-4-yl) methylene-indan-1-one (100g, from preparation 1) was hydrogenated using 10% Palladium/carbon (10g, 50% moisture) in a mixture of methanol (1500ml) and methylene chloride (1000ml) at atomospheric pressure. The hydrogen gas was bubbled into the reaction mixture for about 5 hours. The reaction mixture was filtered and the filtrate was concentrated to get the title compound (92 g).

HPLC Purity : 99.8%.

Example 2

Prepration of 2,3-dihydro-5,6-dimethoxy-2-(4-piperidinyl)methyl-indan-1-one, hydrochloride

A mixture of 5,6-dimethoxy-2-(4-pyridyl)methyl-indan-1-one (25g from example 1), methanol (125ml), water (125ml), conc. hydrochloric acid(12.5g) and platinum dioxide (2.5g) was hydrogenated at 15 to 20 psi hydrogen pressure for about 6 hours. The reaction mixture was filtered, the filtrate was concentrated and the residue so obtained was crystallized from methanol to get the title compound (24g).

HPLC Purity: 99.4%.

Example 3

Preparation of 1-benzyl-4-((5,6-dimethoxy-1-indanone)-2-yl)methylpiperidine, hydrochloride (donepezil hydrochloride)

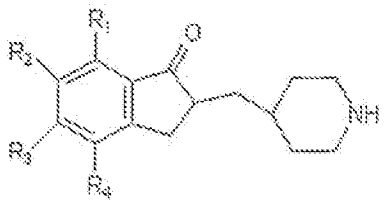
To a stirred mixture of 2,3-dihydro-5,6-dimethoxy-2-(4-piperidinyl)methyl-indan-1-one, hydrochloride (10g from example 2), tetrabutyl ammonium bromide (1g), potassium carbonate (9g) in a mixture of water (40ml) and methylene chloride (50ml) was added benzyl bromide (5.3g) at 20-25°C over 30 minutes. After the addition was over, the reaction mixture was stirred at the same temperature for about 30 minutes. The organic layer was separated and stirred with a mixture of water (20ml) and conc. hydrochloric acid (6.4g) at 20-25°C for 15 minutes. The organic layer was separated and concentrated. The residue so obtained was dissolved in water (100ml) and extracted with ethyl acetate (50ml). The organic layer was discarded and pH of the aqueous layer was adjusted to 9.5 with aqueous ammonia solution (3.5ml). The aqueous solution was then extracted with ethyl acetate (50ml). The ethyl acetate extract was washed with water. The organic layer was concentrated and the residue was dissolved in methanol (50ml). To this solution, conc. hydrochloric acid (4.8g) diluted with methanol (10ml) was added. Diisopropylether (120ml) was then added to the solution at 25°C. It was further stirred at 5 to 10°C and the separated solid was filtered and dried to get crystals of donepezil hydrochloride (10g).

HPLC Purity: 99.95%.

While the present invention has been described in terms of its specific embodiments, certain modifications and equivalents will be apparent to those skilled in the art and are intended to be included within the scope of the present invention.

We claim:

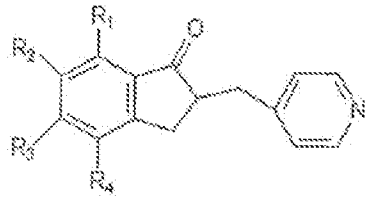
1. A process for the preparation of 2-(4-piperidinyl) methyl-1-indanone of formula II, or a salt thereof,



Formula II

wherein R^1, R^2, R^3, and R^4 are identical or different, and represent hydrogen, straight or branched -chain alkyl, alkoxy, alkoxycarbonyl, alkyl- or dialkyl-aminocarbonyloxy, trifluoromethyl, or halogen,

the process comprising reducing 2-(4-pyridyl) methyl-1-indanone of formula III, or a salt thereof,



Formula III

wherein R^1, R^2, R^3, and R^4 are as defined above; and recovering the 2-(4-piperidinyl) methyl-1-indanone of formula II.

2. The process of claim 1, wherein R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy in formula II and formula III.

3. The process of claim 1, wherein the reduction comprises hydrogenation in the presence of a catalyst.

4. The process of claim 3, wherein the catalyst comprises one or more of platinum oxide, ruthenium oxide, and rhodium/carbon.

5. The process of claim 3, wherein the hydrogenation is carried out at a pressure of from about 1 to about 2 atmospheres using hydrogen gas.

6. The process of claim 3, wherein the hydrogenation is carried out at a temperature of from about 10°C to about 35°C.

7. The process of claim 3, wherein the hydrogenation is carried out in a solvent.

8. The process of claim 7, wherein the solvent comprises one or more of ethers, alcohols, chlorinated hydrocarbons, esters, ketones, hydrocarbons, polar aprotic solvents, water and mixtures thereof.

9. The process of claim 8, wherein the alcohol comprises one or more of methanol, ethanol, propanol, isopropanol and butanol.

10. The process of claim 8, wherein the ether comprises one or more of dibutyl ether, methyl tert-butyl ether, dioxane and tetrahydrofuran.

11. The process of claim 8, wherein the chlorinated hydrocarbon comprises one or more of dichloromethane, tetrachloromethane and dichloroethylene.

12. The process of claim 8, wherein the ester comprises one or more of ethyl acetate and isopropyl acetate.

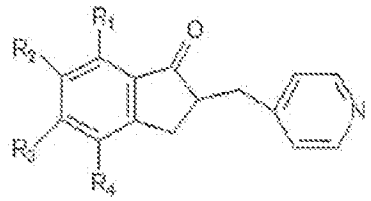
13. The process of claim 8, wherein the ketone comprises one or more of acetone and methylisobutylketone.

14. The process of claim 8, wherein the hydrocarbon comprises one or more of hexane, toluene, and xylene.

15. The process of claim 8, wherein the polar aprotic solvent comprises one or more of dimethylformamide, dimethyl sulphoxide, and N-methylpyrrolidone.

16. The process of claim 1, wherein the recovering comprises one or more of distillation, distillation under vacuum, filtration, filtration under vacuum, decantation, and centrifugation.

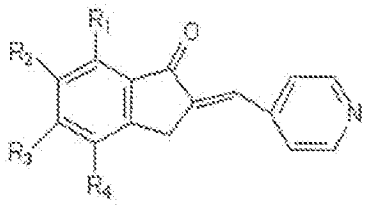
17. A process for the preparation of 2-(4-pyridyl) methyl-1-indanone of formula III, or a salt thereof,



Formula III

wherein R^1, R^2, R^3, and R^4 are identical or different, and represent hydrogen, straight or branched -chain alkyl, alkoxy, alkoxycarbonyl, alkyl- or dialkyl-aminocarbonyloxy, trifluoromethyl, or halogen,

the process comprising selectively reducing 2-(4-pyridyl) methylene-1-indanone of formula IV, or a salt thereof,



Formula IV

wherein R^1, R^2, R^3, and R^4 are as defined above; and recovering the 2-(4-pyridyl) methyl-1-indanone of formula III.

18. The process of claim 17, wherein R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy in formula III and formula IV.

19. The process of claim 17, wherein the reduction comprises hydrogenation in the presence of a catalyst.

20. The process of claim 17, wherein the catalyst comprises one or more of palladium/carbon, platinum/carbon and Raney nickel.

21. The process of claim 17, wherein the hydrogenation is carried out at a temperature of from about 10°C to about 35°C.

22. The process of claim 17, wherein the hydrogenation is carried out in a solvent.

23. The process of claim 22, wherein the solvent comprises one or more of ethers, alcohols, chlorinated hydrocarbons, esters, ketones, hydrocarbons, polar aprotic solvents, water, and mixtures thereof.

24. The process of claim 22, wherein the alcohol comprises one or more of methanol, ethanol, propanol, isopropanol and butanol.

25. The process of claim 22, wherein the chlorinated hydrocarbon comprises one or more of dichloromethane, tetrachloromethane and dichloroethylene.

26. The process of claim 22, wherein the ether comprises one or more of dibutyl ether, methyl tert-butyl ether, dioxane and tetrahydrofuran.

27. The process of claim 22, wherein the ester comprises one or more of ethyl acetate and isopropyl acetate.

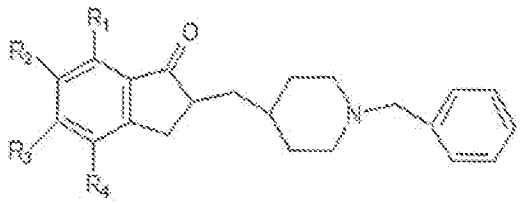
28. The process of claim 22, wherein the ketone comprises one or more of acetone and methylisobutylketone.

29. The process of claim 22, wherein the hydrocarbon comprises one or more of hexane, toluene, and xylene.

30. The process of claim 22, wherein the polar aprotic solvent comprises one or more of dimethylformamide, dimethyl sulphoxide, and N-methylpyrrolidone.

31. The process of claim 17, wherein the recovering comprises one or more of distillation, distillation under vacuum, filtration, filtration under vacuum, decantation, and centrifugation.

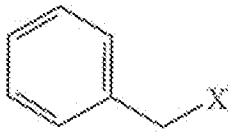
32. A process for the preparation of benzyl-piperidylmethyl-indanones of formula I, or a salt thereof,



Formula I

wherein R^1, R^2, R^3, and R^4 are identical or different, and represent hydrogen, straight or branched -chain alkyl, alkoxy, alkoxycarbonyl, alkyl- or dialkyl-aminocarbonyloxy, trifluoromethyl, or halogen,

the process comprising reacting 2-(4-piperidinyl) methyl-1-indanone of the formula II, or a salt thereof, prepared by the process of claim 1, with a benzyl derivative of formula V,



Formula V

wherein X is a leaving group; and recovering the benzyl-piperidylmethyl-indanones of formula I.

33. The process of claim 32, wherein the leaving group X in the benzyl derivative of formula V is chloride, bromide, iodide, tosylate, or sulphate.

34. The process of claim 32, wherein the reaction is carried out in the presence of a base and a phase transfer catalyst.

35. The process of claim 34, wherein the base comprises one or more of an amine, an inorganic base and ammonia.

36. The process of claim 35, wherein the inorganic base is an alkali metal carbonate.

37. The process of claim 36, wherein the alkali metal carbonate comprises one or more of lithium carbonate, potassium carbonate and sodium carbonate.

38. The process of claim 34, wherein the phase transfer catalyst is comprises one or more of quaternary ammonium salt, or quaternary phosphonium salt.

39. The process of claim 38, wherein the quaternary ammonium salt comprises one or more of tetramethylammonium iodide, tetrabutylammonium iodide, teramethyl-2-butylammonium chloride, trimethylcyclopropylammonium chloride, tetrabutylammonium bromide, and t-butylethyldimethylammonium bromide.

40. The process of claim 32, wherein the reaction is carried out at a temperature of from about 0°C to about 40°C.

41. The process of claim 32, wherein the reaction is carried out in a solvent.

42. The process of claim 41, wherein the solvent comprises one or more of ethers, alcohols, chlorinated hydrocarbons, esters, ketones, hydrocarbons, polar aprotic solvents, water and mixtures thereof

43. The process of claim 42, wherein the alcohol comprises one or more of methanol, ethanol, propanol, isopropanol and butanol.

44. The process of claim 42, wherein the ether comprises one or more of dibutyl ether, methyl tert-butyl ether, dioxane and tetrahydrofuran.

45. The process of claim 42, wherein the chlorinated hydrocarbon comprises one or more of dichloromethane, tetrachloromethane and dichloroethylene.

46. The process of claim 42, wherein the ester comprises one or more of ethyl acetate and isopropyl acetate.

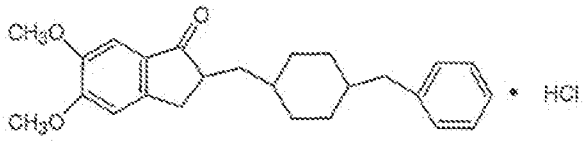
47. The process of claim 42, wherein the ketone comprises one or more of acetone and methylisobutylketone.

48. The process of claim 42, wherein the hydrocarbon comprises one or more of hexane, toluene, and xylene.

49. The process of claim 42, wherein the polar aprotic solvent comprises one or more of dimethylformamide, dimethyl sulphoxide, and N-methylpyrrolidone.

50. process of claim 32, wherein the recovering comprises one or more of distillation, distillation under vacuum, filtration, filtration under vacuum, decantation, and centrifugation.

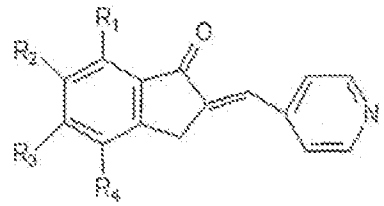
51. A process e preparation of donepezil of formula VI or a pharmaceutically acceptable salt thereof,



Formula VI

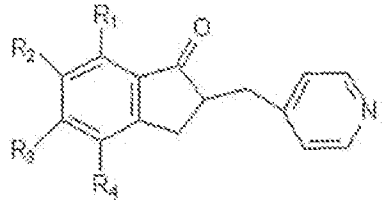
the process comprising:

(a) selectively reducing 2-(4-pyridyl) methylene-1-indanone of formula IV, or a salt thereof,



Formula IV

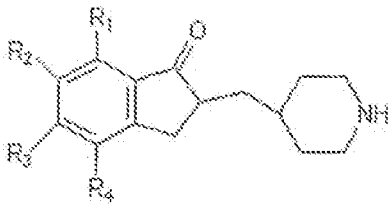
to obtain 2-(4-pyridyl) methyl-1-indanone of formula III,



Formula III

wherein R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy in formula III and formula IV,

(b) reducing the 2-(4-pyridyl) methyl-1-indanone of formula III to obtain 2-(4-piperidinyl) methyl-1-indanone of formula II,

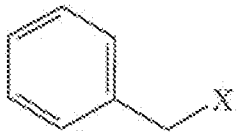


Formula II

wherein R^1 and R^4 represent hydrogen and R^2 and R^3 represent methoxy,

(c) reacting the 2-(4-piperidinyl) methyl-1-indanone of formula II,

with a benzyl derivative of formula V,



Formula V

wherein X is a leaving group, in the presence of an inorganic base and a phase transfer catalyst, and

(d) recovering the donepezil or a pharmaceutically acceptable salt thereof.

52. he process of claim 51, wherein the leaving group X in the benzyl derivative of formula V is chloride, bromide, iodide, tosylate, or sulphate.

53. pharmaceutical composition comprising a therapeutically effective amount of donepezil or a pharmaceutically acceptable salt thereof obtained by the process of claim 51; and one or more pharmaceutically acceptable carriers, excipients or diluen.

INTERNATIONAL SEARCH REPORT

Int ernal Application No
P.../IB2004/000843

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 A61K31/4465 C07D211/32 C07D213/50

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 C07D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)
EPO-Internal, WPI Data, PAJ, BEILSTEIN Data, CHEM ABS Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,X	US 6 649 765 B1 (PANDURANG SUTAR RAJIV ET AL) 18 November 2003 (2003-11-18) column 3, lines 10-14	1-16,51, 52
X	US 6 413 986 B1 (EFFLAND RICHARD C ET AL) 2 July 2002 (2002-07-02) cited in the application see reaction scheme of columns 9 and 10	1-16,51, 52
X	US 6 252 081 B1 (IIMURA YOICHI) 26 June 2001 (2001-06-26) cited in the application see column 3, last step	1-16,51, 52
X	WO 97/22584 A (PFIZER ; DEVRIES KEITH M (US)) 26 June 1997 (1997-06-26) cited in the application page 5	1-16,51, 52

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[X] Further documents are listed in the continuation of box C.

[X] Patent family members are listed in annex.

° Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search	Date of mailing of the international search report
22 July 2004	10/08/2004

Name and mailing address of the ISA	Authorized officer
European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Tx. 31 651 epo nl, Fax: (+31-70) 340-3016	Bérillon, L

Form PCT/ISA/210 (second sheet) (January 2004)

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 1 086 706 A (EISAI CO LTD) 28 March 2001 (2001-03-28) claim 2	53
X	CLARK J. ET AL.: BIOORGANIC AND MEDICINAL CHEMISTRY LETTERS, 2002, pages 2565-2568, XP002289468 see scheme 1, step c	17-31

INTERNATIONAL SEARCH REPORT

National application No.
PCT/IB2004/000843

Box II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. ☐ Claims Nos.:
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:

3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☐ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.

2. ☒ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.

3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:

4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

☐ The additional search fees were accompanied by the applicant's protest.

☐ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-16, 51-53

Preparation of intermediate II
Preparation of donepezil
Composition containing donepezil

2. claims: 17-31

Preparation of intermediate III

3. claims: claims 32-50

Preparation of derivatives I

INTERNATIONAL SEARCH REPORT

International Application No
PCT/IB2004/000843

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